

Date: Monday, 2/11/2008 2:14:25 PM  
 User: Eric Charbonneau

## Process Sheet

Split.

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BK117 SKIDTUBE ASSEMBLY  
 Job Number : 33139 - 1  
 Estimate Number : 12899  
 P.O. Number :  
 This Issue : 2/11/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : 6/26/2007 Type : LANDING GEAR  
 Previous Run :  
 Written By :  
 Checked & Approved By :  
 Comment : Est Rev:A 07.06.11 New Issue EC

Part Number : D117762011  
 Drawing Number : N/A  
 Project Number : N/A  
 Drawing Revision : ~~WR~~ IJN-D117-762 Rev A 01.07.10  
 Material :  
 Due Date : 7/3/2007 Qty: 1 Um: Each

## Additional Product

Job Number:



Seq. # Machine Or Operation: Description:

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile &amp; type labels per PPP D135-751-011 CHG001

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

N/A PROTOTYPE  
 03.02.12

3.0 D117762041 Replacement Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Replacement Skidtube B32910

4.0 D35121 WEARPLATE



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

WEARPLATE

Batch: B36180

5.0 AN960C10L washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 16.0000 Each(s)

Washer

Batch: M102473

PHOTO

00112

By 1/1/1911

111

111



## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BK117 SKIDTUBE ASSEMBLY

Job Number: 33139

Part Number: D117762011

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

|     |        |      |
|-----|--------|------|
| 6.0 | AN3C4A | BOLT |
|-----|--------|------|



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)  
BOLT  
BATCH: M103641

|     |        |      |
|-----|--------|------|
| 7.0 | AN451A | Bolt |
|-----|--------|------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Bolt  
BATCH: M103648

|     |       |         |
|-----|-------|---------|
| 8.0 | D2972 | Bushing |
|-----|-------|---------|



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)  
Bushing  
BATCH: B14103

|     |           |     |
|-----|-----------|-----|
| 9.0 | MS21042L4 | Nut |
|-----|-----------|-----|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Nut  
BATCH: M100743

|      |     |                                    |
|------|-----|------------------------------------|
| 10.0 | QC4 | INSPECT 100% KITS FOR COMPLETENESS |
|------|-----|------------------------------------|



Comment: INSPECT 100% KITS FOR COMPLETENESS

*PH 08.02.12*

|      |             |                       |
|------|-------------|-----------------------|
| 11.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|------|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1  
Identify and pack for shipping as per PPP D135-751-011  
Location: \_\_\_\_\_  
PPP Rev: \_\_\_\_\_

*N/A Prototype ONLY FOR CONFORMITY*

|      |      |                              |
|------|------|------------------------------|
| 12.0 | QC21 | FINAL INSPECTION/W/O RELEASE |
|------|------|------------------------------|



Comment: FINAL INSPECTION/W/O RELEASE

*08-02-12*  
*08/04/07*

Job Completion





**DART**

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<http://www.dartaero.com>

## INSTALLATION INSTRUCTIONS

IIN-D117-762

### *Skidtube Installations*

EUROCOPTER BK 117 A-1/A-3/A-4/B-1/B-2/C-1 MODELS

Prepared By: \_\_\_\_\_

*33139-1*  
*PH*  
*03.07.10*  
*[Signature]*  
P. Hum  
Mechanical Designer

Checked By: \_\_\_\_\_

*[Signature]*  
D. Shepherd, P. Eng  
Design Engineer

Released By: \_\_\_\_\_

*[Signature]*  
D. Shepherd, P. Eng  
Design Engineer

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Revision: **A**

Date: 07.04.27





## 5.0 PARTS LIST

## 5.1 D117-762-011 Skidtube Parts List

| Item | Qty<br>-011 | Qty<br>-041 | Part Number         | Description              |
|------|-------------|-------------|---------------------|--------------------------|
|      | X           |             | D117-762-011        | SKIDTUBE INSTALLATION    |
|      | 1           | X           | D117-762-041        | REPLACEMENT SKIDTUBE     |
| 1    |             | 1           | D3582-041           | SKIDTUBE ASSEMBLY        |
| 2    | 2           |             | **1121-51002        | SKID SHOE                |
| 3    | 2           |             | **1121-51102        | CLAMPING RING            |
| 4    | 8           |             | **LN9380M8X45       | HEXAGON BOLT             |
| 5    | 8           |             | **LN9023A8-1.4544.9 | LOCKING WASHER           |
| 6    | 8           |             | **LN9025-0815K      | WASHER (OR LN9025-0815L) |
| 10   |             | 1           | *D2965              | CAP                      |
| 11   |             | 2           | ***AELS-1032-225    | INSERT                   |
| 12   |             | 2           | *AN3C5A             | BOLT                     |
| 13   |             | 2           | *AN960C10L          | WASHER                   |
| 20A  |             | 1           | *D3508-9            | WEARPLATE                |
| 20B  |             | 1           | *D3558-9            | GASKET                   |
| 21A  |             | 1           | *D3508-3            | WEARPLATE                |
| 21B  |             | 1           | *D3558-3            | GASKET                   |
| 22A  |             | 1           | *D3508-11           | WEARPLATE                |
| 22B  |             | 1           | *D3558-11           | GASKET                   |
| 23A  |             | 1           | *D3508-13           | WEARPLATE                |
| 23B  |             | 1           | *D3558-13           | GASKET                   |
| 24   |             | 36          | *AELS-1032-130      | INSERT                   |
| 25   | 8           | 28          | *AN3C4A             | BOLT                     |
| 26   | 8           | 28          | *AN960C10L          | WASHER                   |
| 27   | 2           |             | D3512-1             | WEARPLATE                |
| 30   |             | 2           | *AELS-1032-130      | INSERT                   |
| 31   |             | 2           | *AN4-4A             | BOLT                     |
| 32   |             | 2           | *AN960JD416L        | WASHER                   |
| 40   |             | 2           | *D3492-049          | PLUG ASSEMBLY            |
| 41   |             | 2           | ***NAS1611-016      | O-RING                   |
| 42   |             | 2           | *D3492-051          | PLUG ASSEMBLY            |
| 43   |             | 2           | ***NAS1611-015      | O-RING                   |
| 44   |             | 6           | *D3492-053          | PLUG ASSEMBLY            |
| 45   |             | 6           | ***NAS1611-012      | O-RING                   |
| 50   | 2           |             | AN4-51A             | BOLT                     |
| 51   | 4           |             | D2972               | BUSHING                  |
| 52   | 2           |             | MS21042L4           | NUT (OR MS21042-4)       |

\* PART IS INCLUDED WITH D3582-041 SKIDTUBE ASSEMBLY

\*\* TO BE SUPPLIED BY CUSTOMER, LISTED AS REFERENCE ONLY

\*\*\* DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE

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Revision: A

Date: 07.04.27

33139-1  
 P& 08.07.10

